

Work Order ID 119663

Friday, May 16, 2014 1:58:49 PM

SPUT

119663

Page 1

Item ID: D3537-1

Revision ID:

Item Name: Wearpad

Start Date: 5/15/14

Start Qty: 50.00

Accept

(S6)

50

50

N900040100

Setup Start

Stop

NS1

NS2

Required Date: 5/15/14

Req'd Qty: 50.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-05-23 Tooling:

QC: _____ Date: _____ SPC (Y/N): _____

Run Start

Stop

NR1

NR2

Sequence ID:

Work Center ID

Operation Description

Set Up/
Run Hours

Tool ID

Tool #

Plan

Accept

Reject

Reject

Insp.

Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr
if necessary

60

0

Jan 14-05-24
mm

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

60

0

Jan 14-05-24
mm

120

QC3- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

0.00 14-05-27

60

0

mm

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Page 2

Item ID: D3537-1

Accept

Revision ID:

Item Name: Wearpad

Start Date: 5/15/14 Start Qty: 50.00

50

Required Date: 5/15/14 Req'd Qty: 50.00

50

Reference:

N900040100

Setup

Start

NS1

Stop

NS2

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

0.00

DAS

30

9-89

60

14-05-27

Brake NC

Memo

0.00

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-
Identify as D3537-1

140

140

Larg. Fab

Large Fab

0.00

Large Fab

Memo

0.00

M123895 M129883 Qty Description Batch A/R 2059B Hardcoat
1-Weld as per Dwg D3537 using Jig DT 82102-Remove any
weld that penetrated through Wearpad if necessary

60

14-05-29

BSR

150

150

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

60

14-05-30

DAS

9-89

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Page 3

Item ID: D3537-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2

Start Date: 5/15/14 Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QCS- Inspect part completeness to step on W/O

0.00

DAS

160

QC

Quality Control

(60) 14.05.30 9-89

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

DAS
34
9-89

170

Powdercoat

Powder Coating

180

QC3- Inspect Part Finish

0.00

SPH
14/5/13

180

QC

Quality Control

56

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Page 4

Item ID: D3537-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2

Start Date: 5/15/14 Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: F12-00d	0.00							

1Q01

Packaging

Packaging

200 QC21- Final Inspection - Work Order Release 0.00

200

QC

Quality Control

Memo 0.00

X56 of 44 uul6103

MLJ 14-06-03

uul603

Picklist Print

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Page 1

Work Order ID: 119663

Parent Item: D3537-1

Parent Item Name: Wearpad

119663
D3537-1

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	300.7670	0.106	6	**	JM14-05-24.	

M304S16GA

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	300.767	
M127821	75.567	
M128423	1.2	
M129192	224	129192

DART AEROSPACE LTD	Work Order:	19663
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	JM	Audited by:	DAS 27	Prototype Approval:	N/A
Date:	14-05-24	Date:	14-05-27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

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WITHOUT NOTICE

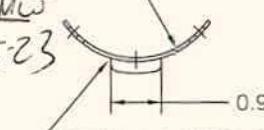
WORK ORDER

NO. 119663MJ

14-05-23

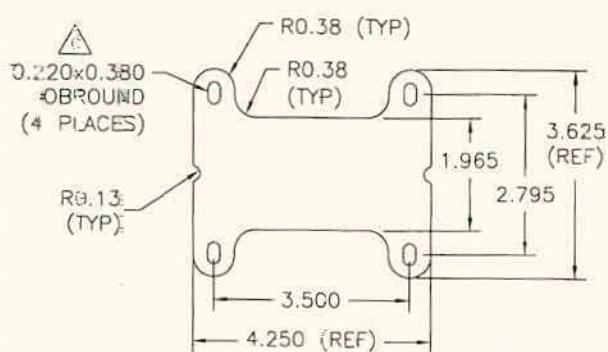
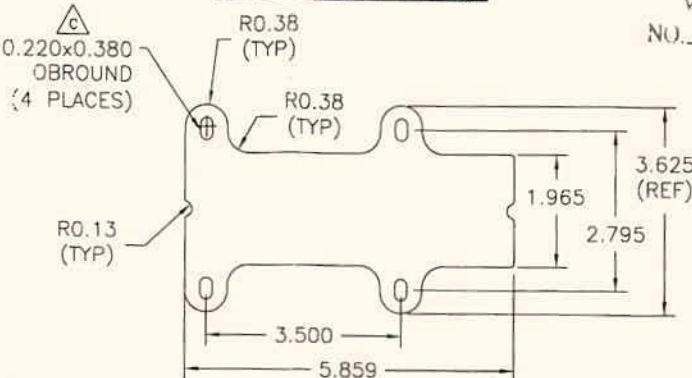
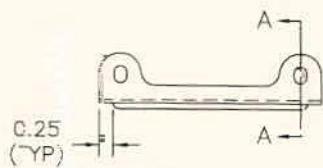
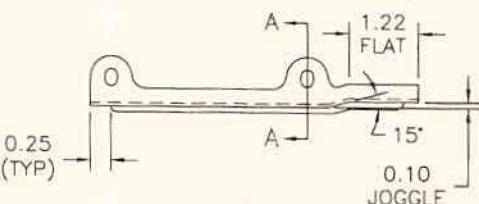
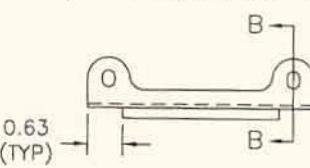
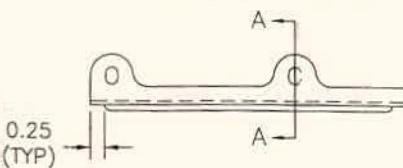
SECTION A-A

R1.62



OK QH.15

UNDER REVIEW

RELEASED
02-05-08 PH
per ECR 962D3537-1F FLAT PATTERND3537-3F FLAT PATTERND3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH DART AEROSPACE USA, INC. POTTER HADLOCK, MA
CHECKED	✓	APPROVED ✓
		DRAWING NO. D3537 REV. C SHEET 1 OF 1
DATE	07.04.13	TITLE WEARPAD SCALE 1:2